

Work Order ID 57522

April 8, 2010 7:32:26 AM



Page 1

Item ID: D3204-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 4/08/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/13/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

V

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3204

☐ Dwg Rev: A1

☐ Prog Rev: A1

☐ 2-

Deburr if necessary

6061 385x1

MAT NOT PULLED

VB 10-4-13



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

VB 10-4-13

120

CONVENTIONAL MILLING MACHINE

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

1-Face to size .300" ☐ 2-Open hole to .191" as per Dwg D3204 ☐ 3-Deburr

BF 10/06/02

10/4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 10.00



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Required Date: 4/13/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

*SP 12/05/02**15**0*

QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00

*AP 10.6-4**14*

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00

10-6-4 SP (140)

Packaging

Memo

0.00

Packaging

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Cust Item ID:

Required Date: 4/13/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/07 *[Signature]* *[Stamp]*
MF
10-6-7

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12/06/07	#	During info close found that 15 parts were missing but only 14 were correct as put into shri 21. 100 when						

NOTE: Date & initial all entries

Picklist Print

April 8, 2010 7:32:26 AM

Page 1

Work Order ID: 57522

Parent Item: D3204-11

Parent Item Name: Plate

Comments: IPP: ☐C05.08.11☐Added Step 25☐ KJ/JLM
IPP Rev:D Now on Waterjet 08-01-08 JLM Verified By:EC

Start Date: 4/08/10

Required Date: 4/13/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			100	f	3.6000	1.1189	1.7		



6061T6 BAR .375 x 1.00



B10-4-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT01

3.6

113325

3.6

114352

114352

(15)

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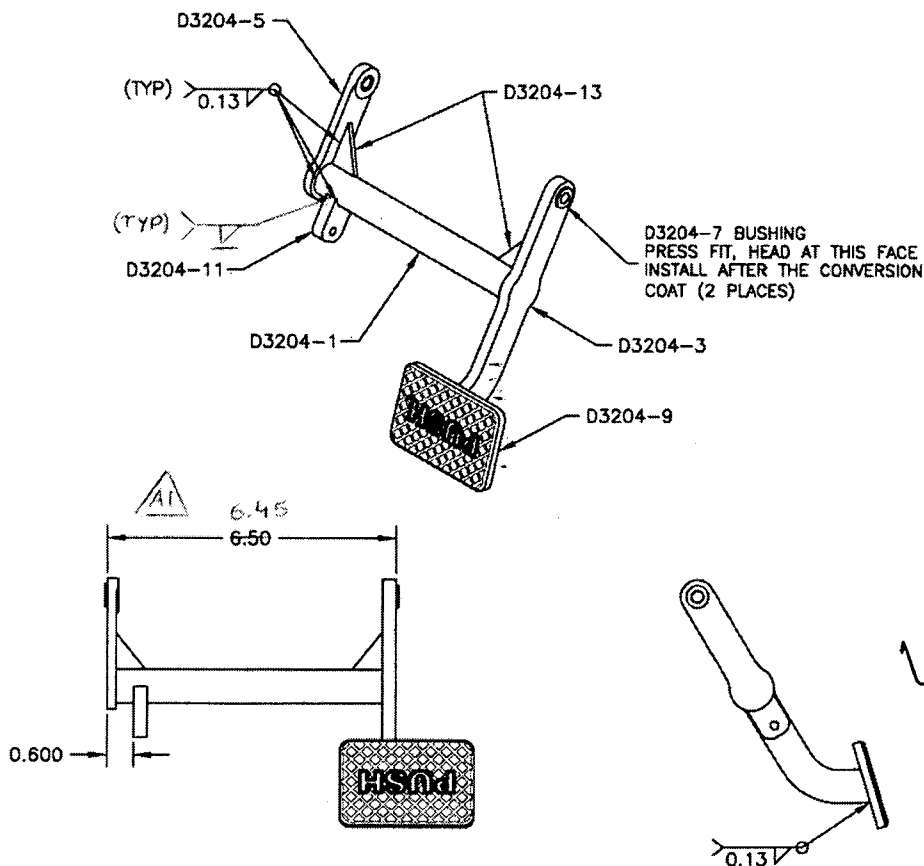
5S basics

- **Sort (Seiri) (整理):** Sorting. Refers to the practice of going through all the tools, materials, etc., in the work area and keeping only essential items. Everything else is stored or discarded. This leads to fewer hazards and less clutter to interfere with productive work.
- **Set in order (Seiton) (整頓):** Simplifying. Focuses on the need for an orderly workplace. "Orderly" in this sense means arranging the tools and equipment in an order that promotes work flow. Tools and equipment should be kept where they will be used, and the process should be ordered in a manner that eliminates extra motion.
- **Shine (Seisō) (清掃):** Sweeping, Systematic Cleaning, or Shining. Indicates the need to keep the workplace clean as well as neat. At the end of each shift, the work area is cleaned up and everything is restored to its place. The key point is that maintaining cleanliness should be part of the daily work - not an occasional activity initiated when things get too messy.



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CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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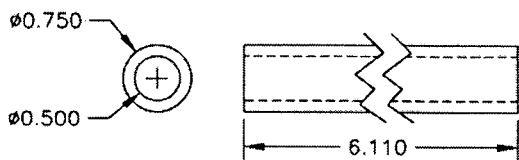
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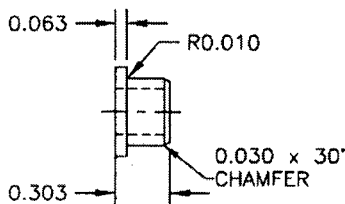


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

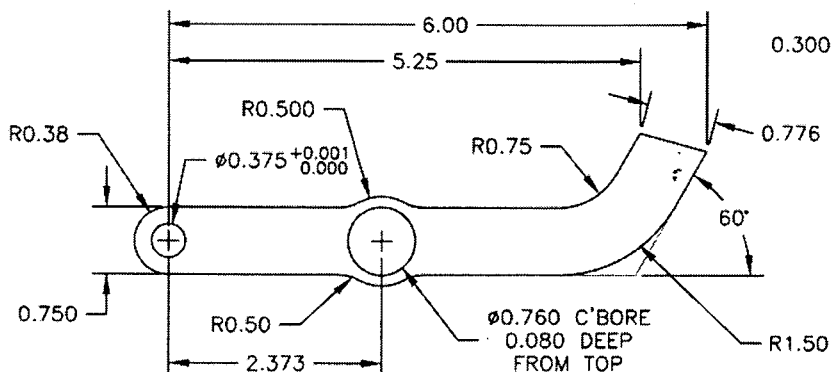
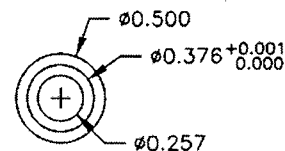
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04.04.05 *[Signature]*



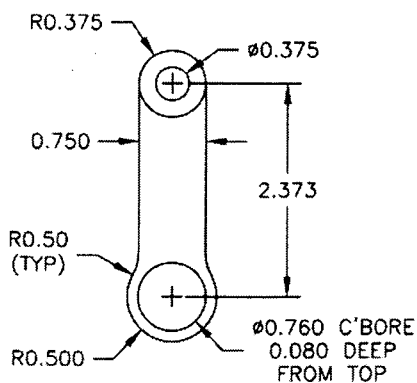
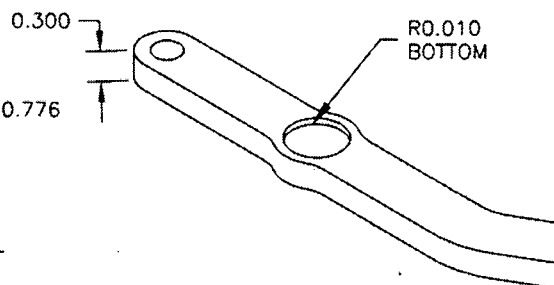
2 D3204-1 TUBE
SCALE 1:2



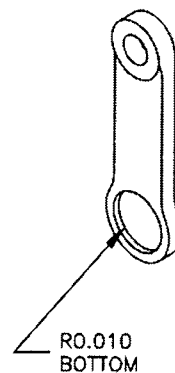
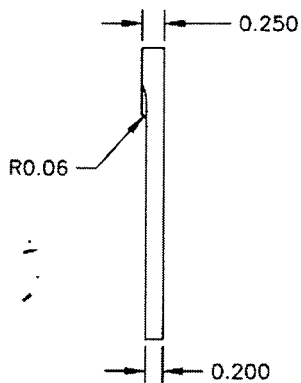
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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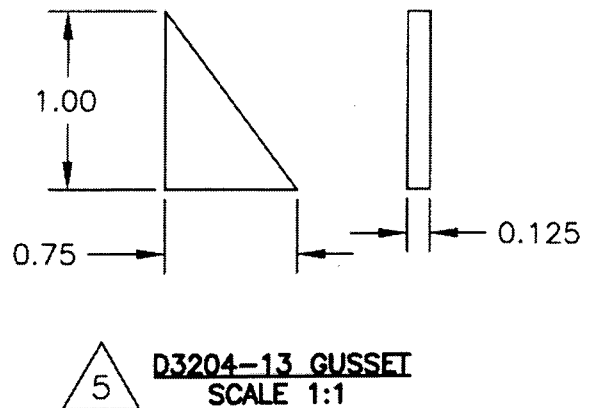
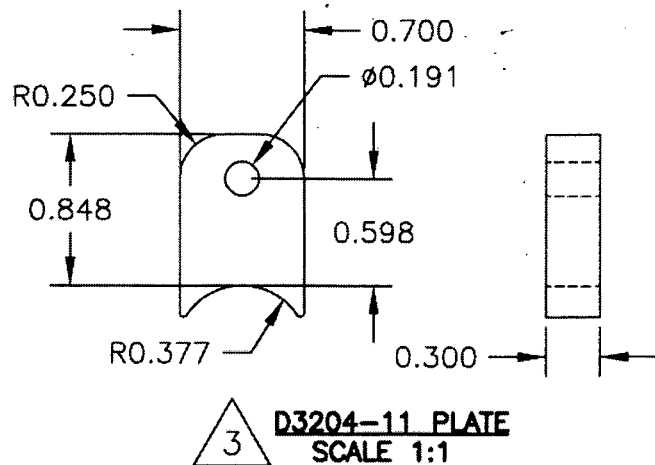
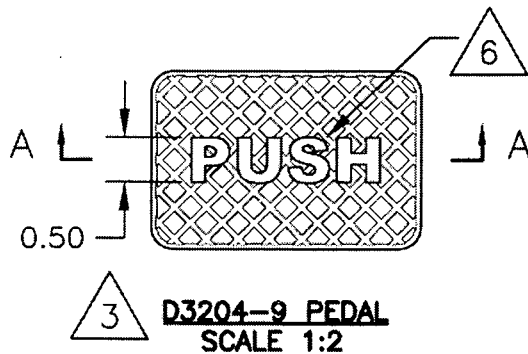
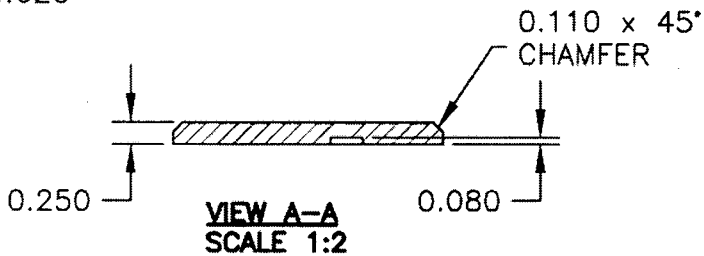
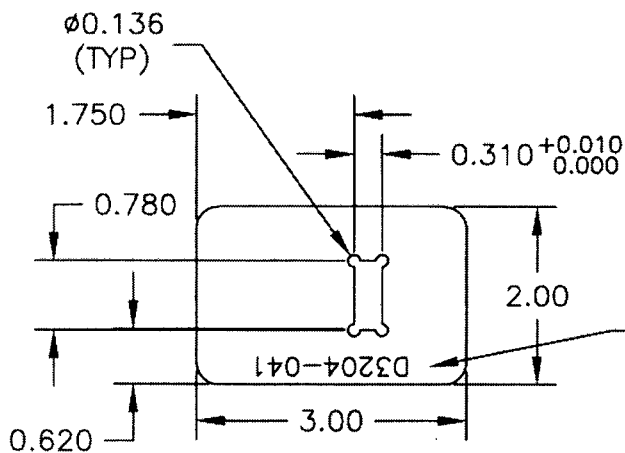
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